

Date: Tuesday, 3/11/2008 7:57:21 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEB ASSEMBLY	
Job Number	37741				
Estimate Number	10194				
P.O. Number			Part Number	D2174041	
This Issue	3/11/2008	S.O. No.	Drawing Number	D2174 REV E	
Prsht Rev.	NC		Project Number	N/A	
First Issue	/ /	Type	Drawing Revision	E	
Previous Run	32856		Material		
Written By			Due Date	4/4/2008	Qty: 12 Um: Each
Checked & Approved By	<u>108 03 11</u>				
Comment	Est: D 04/06/10 Reformat; Changed Step 2 KJ/JLM Est Rev:E As per Rev E 06-11-22 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D21741	Web	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 12	SB 08/04/01
		Web	
		Qty Part Number Description Batch	
		1 D2174-1 Web B31689 ②	B31689 B37848
2.0	D21751	Angle LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 12	SB 08/03/25
		Angle LH	(12)
		Qty Part Number Description Batch	
		1 D2175-1 Angle B31691	SB 08/03/25
3.0	D21752	Angle RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 12	SB 08/03/25
		Angle RH	(12)
		Qty Part Number Description Batch	
		1 D2175-2 Angle B35342	SB 08/03/25
4.0	MS20470AD46	Rivet, Universal Head	
		Comment: Qty.: 19.0000 Each(s)/Unit Total : 190.0000 Each(s) 228 Rivets	
		Rivet, Universal Head ✓	m 107082 x 215
		Qty Part Number Description Batch	
		19 MS20470AD4-6 Rivet M106375 x 13	ml 08/04/01

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & Initial all entries

Date: Tuesday, 3/11/2008 7:57:21 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 37741

Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

ml 08/04/01 (X2)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(S) 08/04/01 (X2)

7.0 POWDER COATING

POWDER COATING



M 107550

(12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL 08-04-02

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-J 08/04/02

(12x)

9.0 AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

921b

AS 08/04/03

(X2)

Batch:



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

M107091

AS 08/04/03

(X2)

Batch:



11.0 MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

M106903

AS 08/04/03

(X2)

Batch:



12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install nuts & bolts loosely as per Dwg D2274

EBO 08/04/03

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:21 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 37741

Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC5

INSPECT WORK TO CURRENT STEP



5 08/04/08 x 12

Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST222

18 08/04/04 x 12

15.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/08 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.04.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

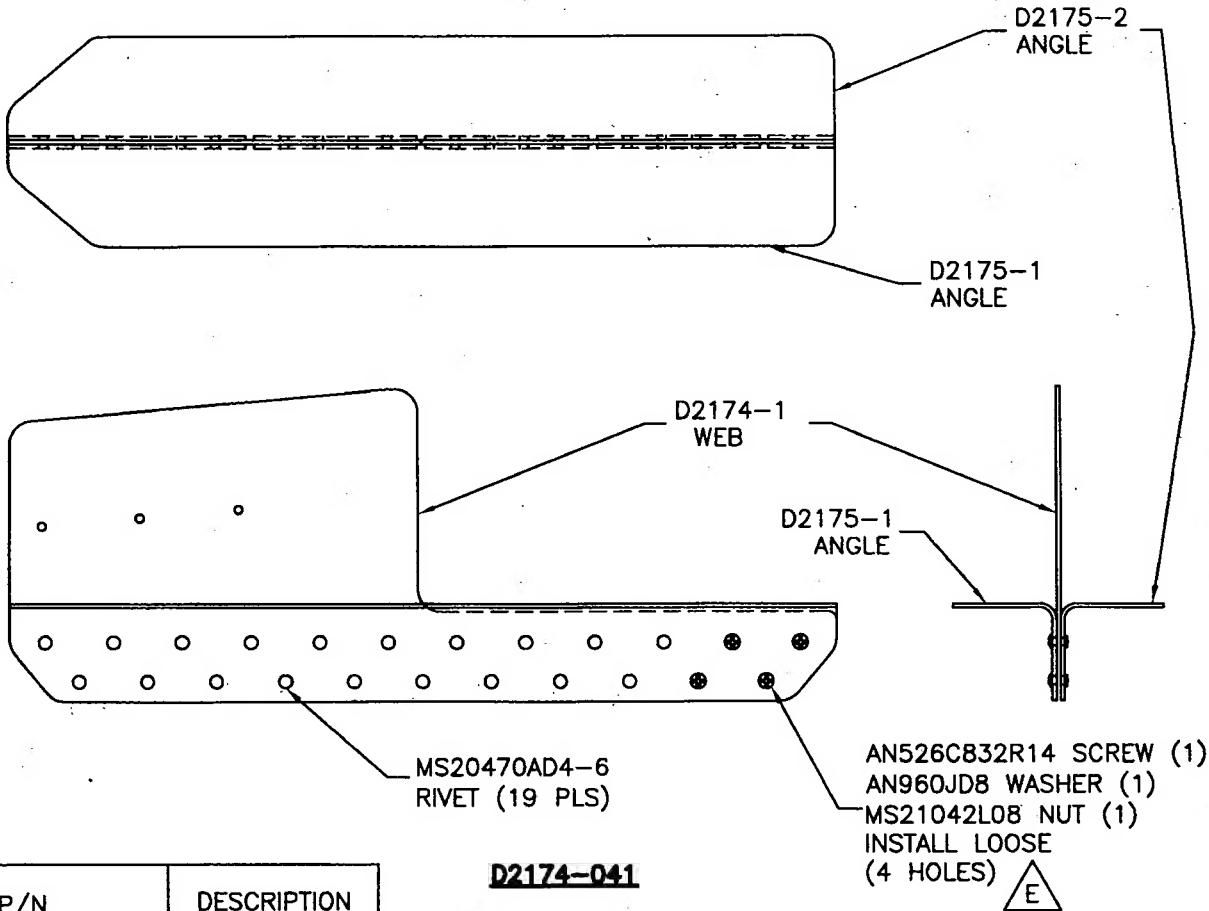
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JH</i>	APPROVED <i>CH</i>	DRAWING NO. D2174
DATE 06.09.25	TITLE WEB ASSEMBLY	REV. E SHEET 1 OF 2 SCALE 1:3
A	95.10.25	NEW ISSUE
B	96.01.18	RE-DRAWN
C	00.09.11	UPDATE FINISH SPEC.
D	04.06.03	RE-DESIGN
E	06.09.25	INC 4 HOLES TO ϕ 0.172; CHG HARDWARE

RELEASED
06-10-13-1

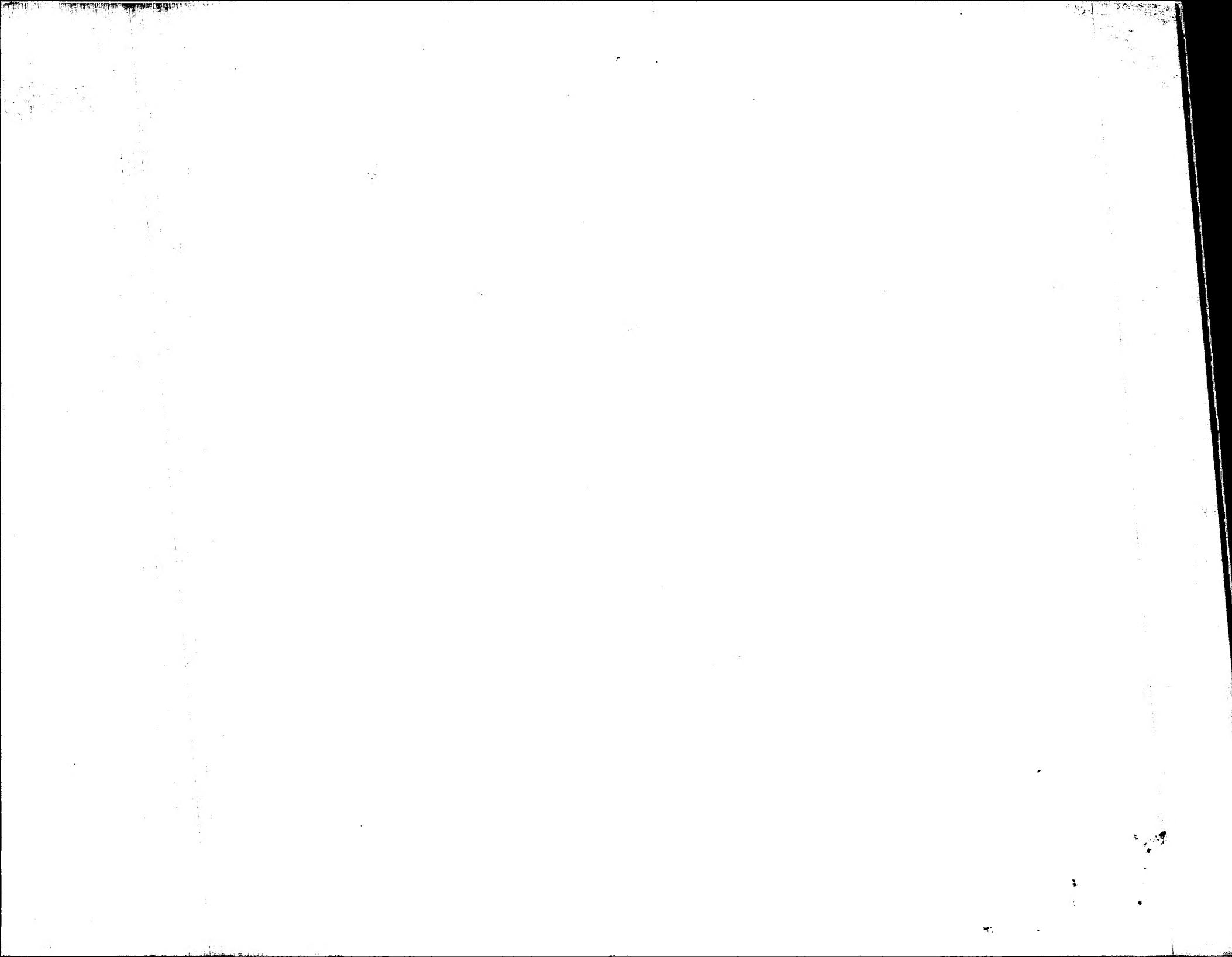
QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

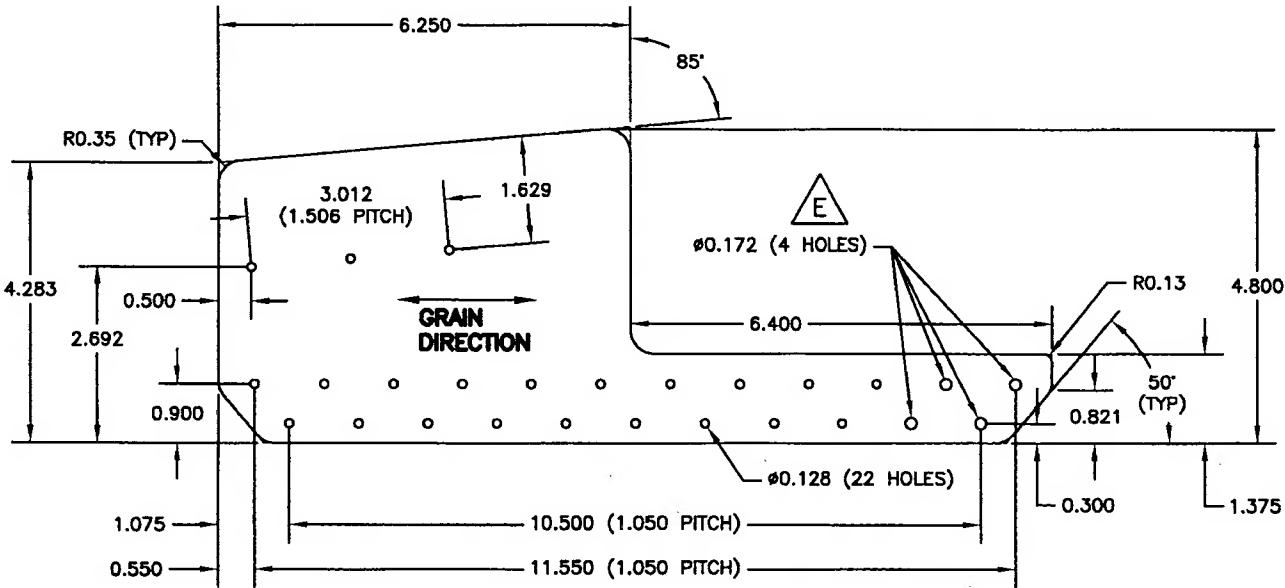
NO. 3774

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.





D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

WORK ORDER NO. 3274
DRAFT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOT TO AMENDMENT
WITHOUT NOTICE

RELEASED
06-16-3

DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2174
DATE 06.09.25	TIME WEB	SCALE 1:3

DART

